

April-30-12 2:37:56 PM

Page -1

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 30/04/2012 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 14/05/2012 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/30

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83974

April-30-12 2:37:56 PM

83974

Page 2

Item ID: D2521

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw 205

Start Date: 30/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 14/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

29 12-7-10

6 4

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

PMP 83973

4/27/10 (16)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/07/10

ME 12-09-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83974

83974

Parent Item: D2521

D2521

Parent Item Name: Bearpaw 205

Start Date: 30/04/2012

Required Date: 14/05/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	231.2100		117.8947	120		

MUHMWB10

UHMW 1" Black

182-5-6

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	30.1	
120972	3	
121346	27.1	
MAT019	1.5	
118814	1.5	
ST052	199.6099947	
121277	12.8	
121278	186.809995	

121278

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83974
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓		vern	RT-4
B	0.90	0.96	.931	✓		"	
C	0.27	0.330	.306	✓		"	
D	0.470	0.530	.515	✓		"	
E	21.740	21.760	21.750	✓		Tape	RT-11
F	0.72	0.780	.751	✓		vern	
G	0.35	0.410	.379	✓		"	
H	11.490	11.570	11.5	✓		Tape	
I	3.41	3.47	3.428	✓		vern	
J	11.790	11.810	11.8	✓		Tape	
K	9.47	9.53	9.5	✓		"	
L	7.190	7.210	7.2	✓		"	
M	6.910	6.970	6.94	✓		"	
N	44.47	44.530	44.5	✓		"	
O	6.590	6.650	6.62	✓		"	
P	0.940	0.980	.954	✓		vern	
Q	18.97	19.03	19.00	✓		Tape	
R	0.350	0.410	.386	✓		vern	
S	0.740	0.780	.762	✓		"	
T	0.240	0.280	.256	✓		"	
U	0.370	0.410	.384	✓		"	
V	0.740	0.780	.754	✓		"	
W	0.740	0.780	.762	✓		"	

Measured by: RT	Audited by: DP	Prototype Approval:	N/A
Date: 12-07-07	Date: 12-7-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28		TITLE	205 BEARPAW	
				SCALE	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83974 MLT
12/04/36

RELEASED

06.08.23 *#*

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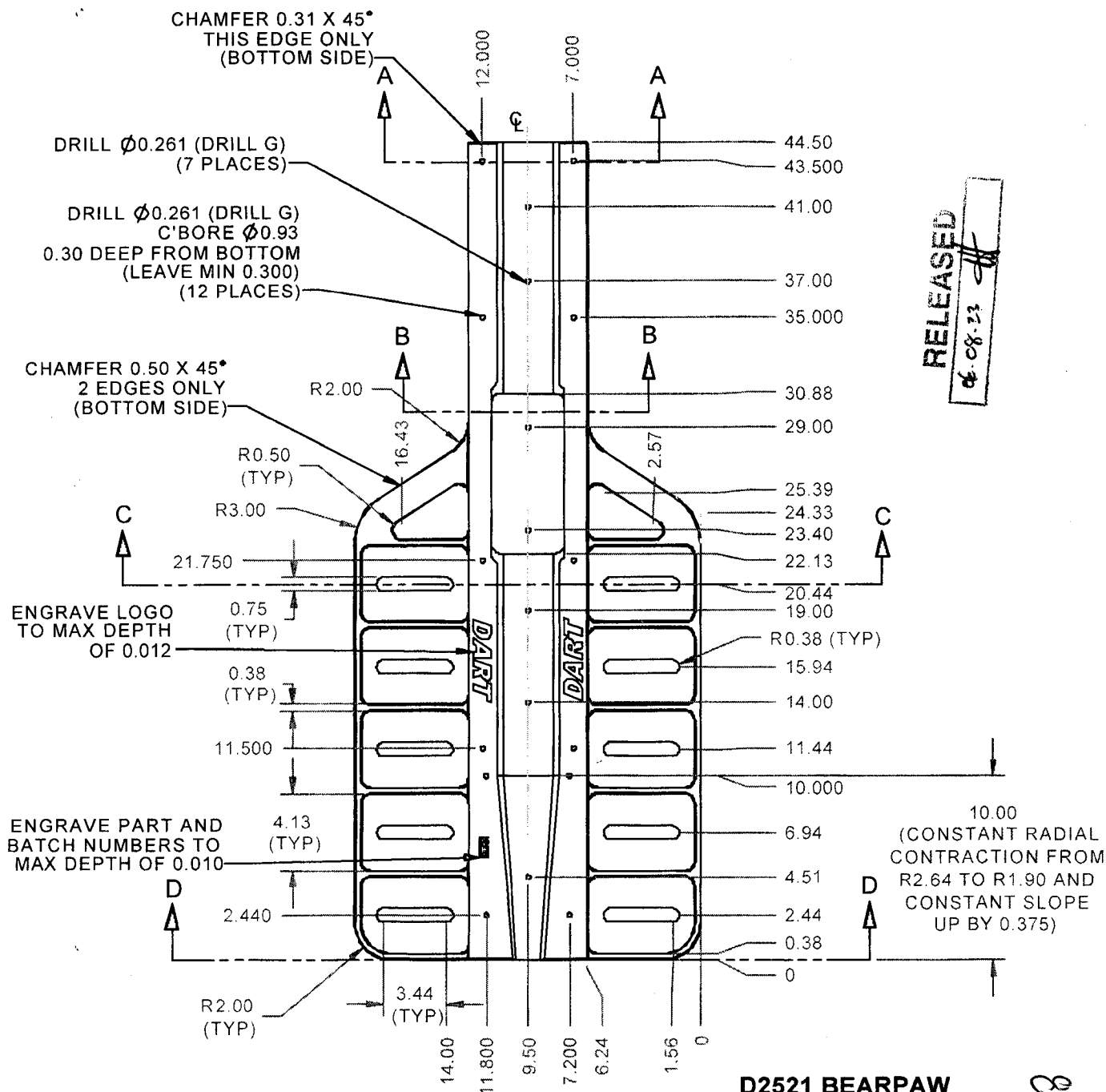
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
		D2521	SHEET 2 OF 3
DATE	TITLE	SCALE	
06.07.28	205 BEARPAW	1:8	



D2521 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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83974

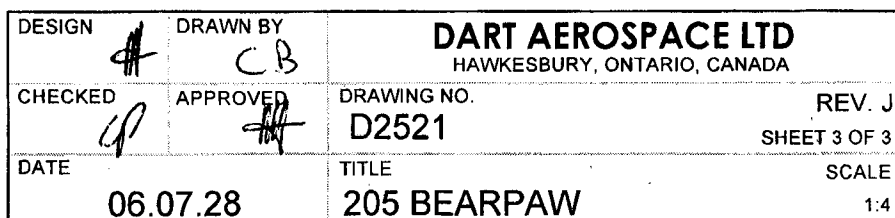
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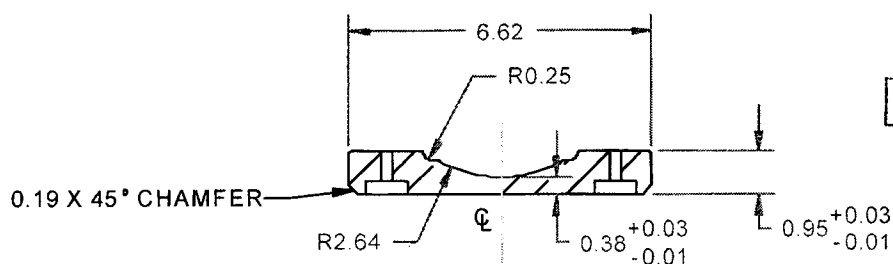
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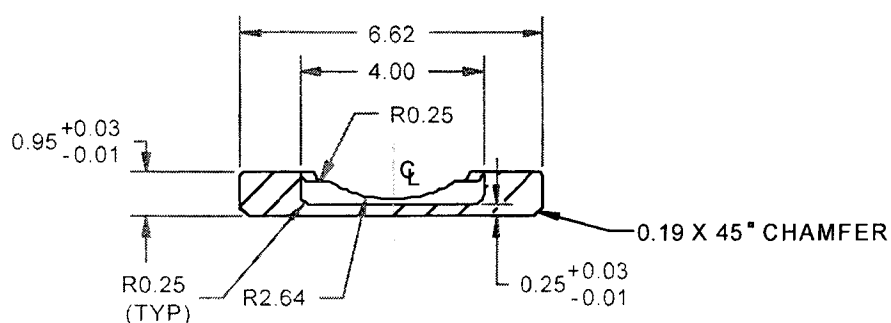


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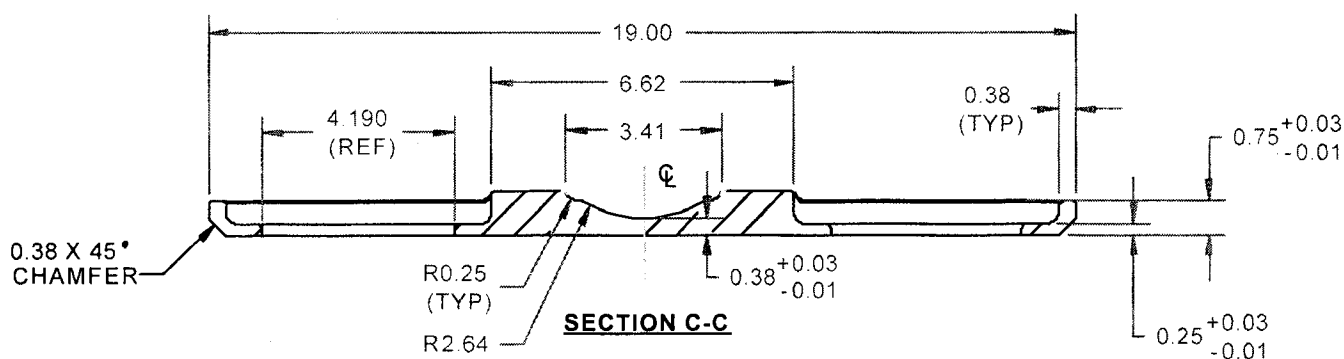
06.08.23



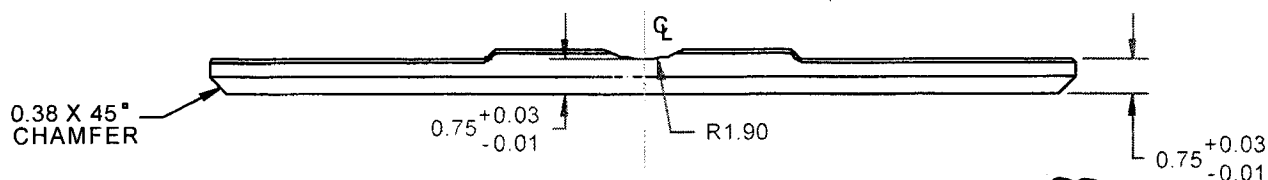
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

4643

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